



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3183-044
Job Sheet 215950



Part No: D3183-044

Job Qty: 4 pcs

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/25/20

Job Tracking No:

Due Date: 12/10/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C1 IPP Rev:Pick:A 04.02.18 New issue KJ/DS IPP Rev:B Changed Mat Size 08-06-26 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	4 pcs	12/9/20	12/9/20	0.00	0.06	Bandsaw - 1		ML 20/12/07
110	HAAS 4 Axis - B4B	4 pcs	12/9/20	12/9/20	0.87	16.67	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		B.A 20-12-06
120	QC 2	4 pcs	12/9/20	12/9/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S319607



Part: D3183 - 044

Job No: 215950

Serial No/Batch: S319607

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/09/20

Plex 11/25/20 8:22 AM Dart.lajeunesse.marie

130 QC 8	4 pcs	12/9/20	0.00 0.00	QC 2 - 63	
				QC 2 - 8	B A 20-12-06
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	DAS 52 10/12/10
				QC 8 - 52	9-89
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				QC 8 - 66	
				QC 8 - 73	
				QC 8 - 82	DAS 58 DEC 10 2020
140 Small Fab - 2 - B4B	4 pcs	12/10/20	0.00 0.21	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Small Fab - 9 - B4B	
				Small Fab - Various 1 - B4B	
150 QC 5	4 pcs	12/10/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	

					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	DEC 1 0 2020 DAS 40 9-89
					QC 5 - 61	
					QC 5 - 81	
					QC 5 - 82	
160	Packaging 3-1 - Stock - B4B	4 pcs	12/10/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	DAS 28 9-89
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	DEC 1 1 2020
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	DAS 28 9-89
170	QC 21 - SA	4 pcs	12/10/20	0.00 0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 9	
					QC 21 - SA - 77	DEC 1 1 2020
					QC 21 - SA - 28	

Part Op 100 - (Bandsaw) Cut blanks: (1.500" x 2.250") 5.500" long
 Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine D3183-4 as per Folio FA322 and Dwg D3183 Identify as D3183-4
 120 - (QC2- Inspect parts off machine FAI/FAIB)

- 130 - (QC8- Inspect parts - second check)
- 140 - (Small Fab) Assemble D3183-044 as per Dwg D3183.
- 150 - (QC5- Inspect part completeness to step on W/O)
- 160 - (Identify as per dwg & Stock Location: _____)
- 170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-B1.500X2.250	17-4 SS Bar 1.50 X2.250	1.8332 ft (.4583 ea)	100-Bandsaw - 1	5138 112 X4
D3121-21 <i>STC18</i>	Bolt	8 pcs (2 ea)	140-Small Fab - 2 - B4B	5308315
D3183-045 <i>221</i>	Bearing Assembly	8 pcs (2 ea)	140-Small Fab - 2 - B4B	5303778 X4 5311245 X4

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M17-4-B1.500X2.250	2	13	0
140-Small Fab - 2 - B4B	D3121-21	8	54	0
	D3183-045	8	48	0

Part Specifications

Specifications could not be found.

Plex 11/25/20 8:22 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order: 215950
Description: Bracket		Part Number: D3183-4
Inspection Dwg: D3183	Rev: C1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.190	+/-0.030	R0.188	✓		R-G	ref.
R0.063	+/-0.010	R0.063	✓		"	"
0.182	+/-0.010	0.185	✓		Vern	GA-13
0.070	+/-0.010	0.0695	✓		H-G	31006
0.100	+/-0.010	0.1025	✓		"	"
Ø0.201 x 0.100	+/-0.010	Ø0.200x.097	✓		Vern	GA-13
0.182	+/-0.010	0.185	✓		H-G	31006
5.32	+/-0.030	5.324	✓		"	"
5.036	+/-0.010	5.040	✓		"	"
2.120	+/-0.010	2.120	✓		"	"
1.290	+/-0.010	1.290	✓		"	"
0.365	+/-0.010	0.366	✓		"	"
0.218	+/-0.010	0.214	✓		Vern	GA-13
1.030	+/-0.010	1.029	✓		H-G	31006
1.90	+/-0.030	1.890	✓		Vern	GA-13
1.012	+/-0.010	1.013	✓		H-G	31006
Ø0.201 x 0.100	+/-0.010	Ø0.200x0.098	✓		Vern	GA-13
0.786	+/-0.010	0.7875	✓		H-G	31006
Ø0.392	+0.002/-0.000	Ø0.3933	✓		Mic	GA-03
R0.19	+/-0.030	R0.188	✓		R-G	ref.
3.954	+/-0.010	3.956	✓		H-G	31006
0.162	+/-0.010	0.162	✓		Mic	GA-03
R0.19	+/-0.030	R0.188	✓		R-G	ref.
R0.25	+/-0.030	R0.250	✓		"	"
4.26	+/-0.030	4.2615	✓		H-G	31006
2.800 Calculated dimension	+/-0.030	2.788	✓		Vern	GA-13
0.162	+/-0.010	0.162	✓		Mic	118-120
0.615	+/-0.010	0.612	✓		Vern	GA-13
0.435	+/-0.010	0.433	✓		"	"
0.200	+/-0.010	0.200	✓		"	"
0.381	+/-0.010	0.380	✓		"	"
0.032	+/-0.010	0.027 ^{DAS}	✓		D-G	GA-08

Measured by: Ba	Audited by: 52	Preliminary Approval:	N/A
Date: 20-12-08	Date: 20/12/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue P/O D3183-044	KJ/RF	
B	04.03.15	Changes as per revision C	KJ/JLM/RF	
C	04.06.15	Dimension 2.800 was 2.080; removed 1.155, 0.36 dimensions	KJ/JLM	
D	06.03.09	Dwg Rev update	KJ/JLM	
E	08.01.16	Dimensions revised	KJ/EC/DD	
F	10.09.23	Dimensions revised	KJ	MA

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					